

Date: Thursday, 3/8/2007 1:19:16 PM
 User: Kipp Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 31125	
Estimate Number : 12634	
P.O. Number : <u>N/A</u>	Part Number : D35491
This Issue : 3/8/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3549 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL / MED FAB	Drawing Revision : A
Previous Run :	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 3/30/2007
Checked & Approved By : <u>[Signature]</u>	Qty: <u>20</u> Um: Each
Comment : Est Rev: A New Issue 06-11-13 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.2205 sf(s)/Unit Total : ~~2.2050 sf(s)~~ 4.4100
 6061-t6 aluminum sheet .080 Sheet
 Batch: 11104186 ml 07 06 08 (20)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3549
 Dwg Rev: A
 Prog Rev: A

ml 07 06 08 (20)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07 06 08 (20)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07 06 12 (18)

(PTC)

5.0	BRAKE NC	NC BRAKE
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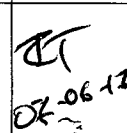
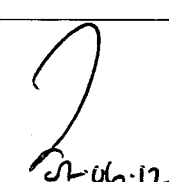
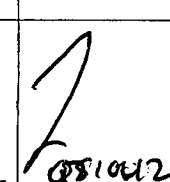
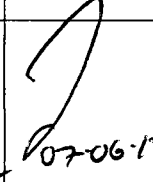
Comment: NC BRAKE
 Form as per Dwg D3549

SB 07 10 06 / 13 (18)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-06-12	40	2 parts scrap. Mild blow-out approximately 0.010" deep, in where the bend is going to be.	 AS1042	Scrap: destroy No replace	 07-06-12	 07-06-12	 AS1042	 07-06-12

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31125

Part Number: D35491

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



June 14 (18)



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS

07-06-15

(18)

8.0

POWDER COATING

POWDER COATING



M 104144



(18)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR/MJ 07-06-18

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/06/19 x18

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *223*

GA -> 2

Store -> 16

ml 07/06/19

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/19

Job Completion



U 07-06-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

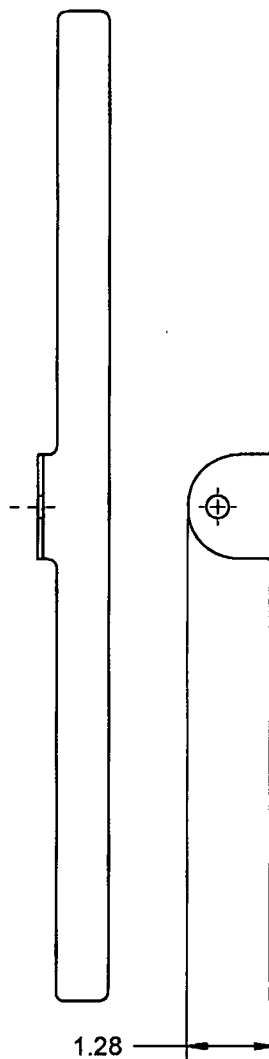
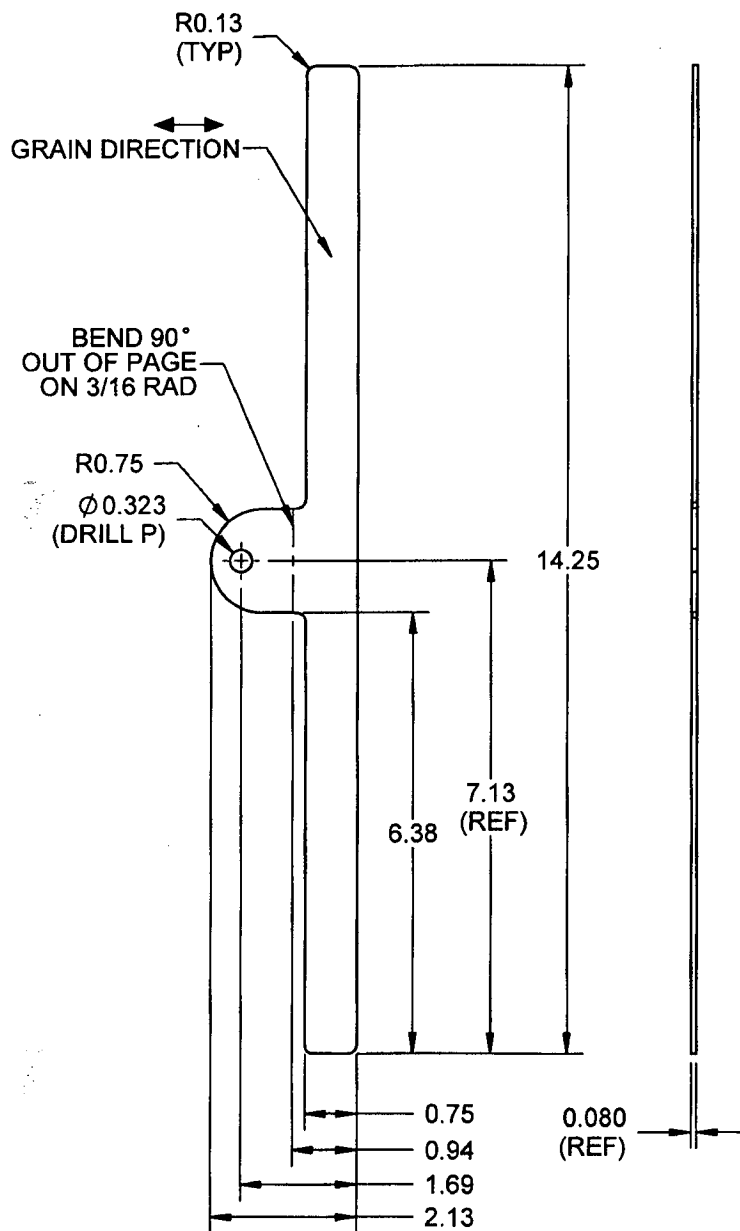
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3549	REV. A SHEET 1 OF 1
DATE 06.10.10		TITLE BRACKET	SCALE 1:1
REV A	DATE 06.10.10	DESCRIPTION NEW ISSUE	



D3549-1 BRACKET

D3549-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.080 THICK PER QQ-A-250/11 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1. POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3549-1 USING FINE POINT PERMANENT MARKER

SHOP COPY
RELEASED
06.10.10 (NT)
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31125

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DART AEROSPACE LTD		Work Order: 31125
Description: Bracket		Part Number: D3549-1
Inspection Dwg: D3549 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

161

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.75	+/- 0.030	0.755	✓		VEN	
B Ø 0.323	+0.006-0.001	0.322	✓		VEN	
C 14.25	+/- 0.030	14.25	✓		M.T	
D 1.69	+/- 0.030	1.694	✓		VEN	
E 6.38	+/- 0.030	6.38	✓		M.T	
F R0.13	+/- 0.030	R0.13	✓		R.G	
G 2.13	+/- 0.030	2.132	✓		VEN	
H 7.13	+/- 0.030	7.125	✓		M.T	
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: ml. ml	Audited by:	Prototype Approval:	N/A
Date: 07 06 08	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

Rush-Monique
DUPLICATE
for g2u005

Dart Aerospace Ltd.

Date: Thursday, 07/06/2007 10:02:57 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 31125	
Estimate Number : 12634	
P.O. Number :	Part Number : D35491
This Issue : 07/06/2007 S.O. No. :	Drawing Number : D3549 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 08/03/2007 Type : SMALL /MED FAB	Drawing Revision : A
Previous Run :	Material :
Written By : <u> </u>	Due Date : 30/03/2007 Qty: 10 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est Rev:A New Issue 06-11-13 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S080	6061-T6 .080 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.2205 sf(s)/Unit Total : 2.2050 sf(s)
6061-t6 aluminum sheet .080 Sheet
Batch:

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
1-Cut as per Dwg D3549
Dwg Rev:
Prog Rev:

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
Form as per Dwg D3549

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 07/06/2007 10:02:57 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31125

Part Number: D35491

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

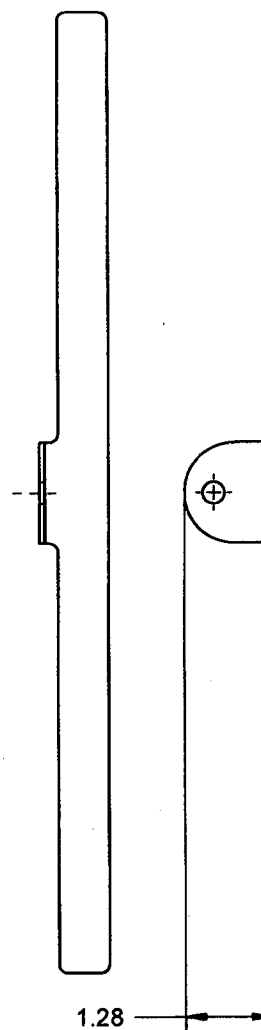
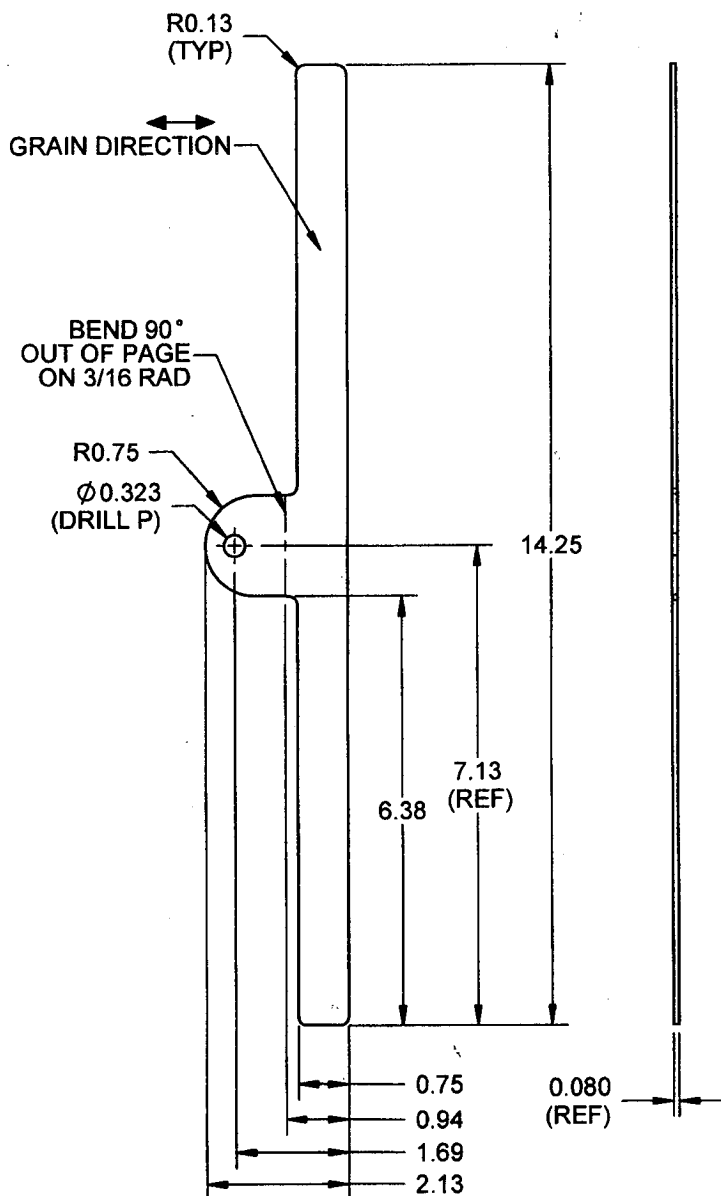
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3549	REV. A SHEET 1 OF 1
DATE 06.10.10	TITLE BRACKET		SCALE 1:1
REV A	DATE 06.10.10	DESCRIPTION NEW ISSUE	



D3549-1 BRACKET



NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.080 THICK PER QQ-A-250/11 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1. POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3.
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- 6) IDENTIFY WITH P/N D3549-1 USING FINE POINT PERMANENT MARKER

D3549-1F FLAT PATTERN

RELEASED
06.10.10

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Date: Thursday, 07/06/2007 9:58:28 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 31125	Customer	: Dart Helicopters Services
Estimate Number	: 12634	DWG Name	: BRACKET
Purchase Order #	:	Part Number	: D35491
Complete Date	: / / : : AM	DWG Number	: D3549 REV A
		Rev.	: A

DUE DATE	ORDERED	DELIVERED
30/03/2007	10	0

2.0 WATER JET Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
11/03/2007	DROU02: Drouin, Steven	Run	0.000	0.10	\$1.61	0.10	9.50

Subtotal:	QTD:	0	CTD:	0	0.10	\$11.11
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	TIME	COST
Machine Time:	0.10	\$9.50
Labor:	0.10	\$1.61
Sub-contract (external Op.):		\$0.00
INVENTORY ITEM:		\$0.00
SUB-COMPONENT (SUB-JOB):		\$0.00
Total:		\$11.11

COST PER UNIT:	\$11.11
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